

BLUE

Dart Aerospace Ltd.

Date: Thursday, 10/05/2007 7:09:58 AM
 User: Linda Lacelle

Process Sheet

Split-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS STEP LH
Job Number	: 32249		
Estimate Number	: 10855		
P.O. Number	: <i>N/A</i>	Part Number	: D206628021 <i>BL</i>
This Issue	: 10/05/2007 S.O. No. : <i>N/A</i>	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 32057	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 15/05/2007 Qty: 2 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: D as per ECN 766 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-021 CHG-002

*CL**07-03-10**(2)**KS.*

2.0	32249A	206L/407 STEP ASSY, LH
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Comment: Sub-Component SUB-COMPONENT

D2724-041 B *B3249 B32249A*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug

B32324 ✓

5.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.1708 f(s)/Unit Total: 2.3415 f(s)

Pick:

Qty Part # Description

2 D2856-400 6.9" Abrasion Strip

*B30822 ✓**7/5/12 SP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/05/2007 7:09:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 32249

Part Number: D206628021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3394043

LUG ASSY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 LUG ASS,Y

7.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-12A Bolt

M103962 ✓

8.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-13A Bolt

M103947 ✓

9.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-15A Bolt

M104072 ✓

10.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD416 Washer

M102929 ✓

11.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21042L4 Nut (or MS21042-4)

M103914 ✓

7/5/12 Sh

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/05/2007 7:09:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 32249

Part Number: D206628021

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



C207105118 (2)



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/5/18 (2)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-021

Location: _____

PPP Rev: _____

E

C207105118 (2)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

C207105118 (2)

Job Completion



U 07/05.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

BLUE

Dart Aerospace Ltd.

Date: Thursday, 10/05/2007 7:10:08 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, LH
Job Number	: 32249A		
Estimate Number	: 11702		
P.O. Number	: <i>N/A</i>	Part Number	: D2724041
This Issue	: 10/05/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2724 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 32057A	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 15/05/2007 Qty: 2 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>B30199</i>

Check Material for any Dents or Defects

FF 07-05-10

2

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

FF 07-05-10

2

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>B29340</i>

FF 07-05-10

2

4.0	D34581	PLATE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	<i>B30908 = 3</i> <i>B3107321</i>

FF 07-05-10

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/05/2007 7:10:08 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32249A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-3	Plate	331014

LE. 07-05-10 2

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch: M102756
M103317

Grind end cap welds flush

LE. 07-05-10 2
LE. 07-05-10 2
LE. 07-05-10 2

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/7/05/11 ②

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/7/05/11 ②

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10/7/05/11 ②

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10/7/05/11 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/05/2007 7:10:08 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/407 STEP ASSY, LH

Job Number: 32249A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

BE 07-05-16

(2)

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig DT

A/R AL ROD

Batch:

M103794/M102421

BE 07-05-16

Grind per dwg D2724

FF 07-05-16

2

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

AD 07-05-16

(2)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

AA

07-05-16

(2)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AT 07-05-17

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-SPRAY PAINT DELFLEET BLUE

-CLEAR COAT DELFLEET

AT 07-05-17

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

B107281

M-A

07/05/18

(2X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/03/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/05/2007 7:10:08 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32249A

Part Number: D2724041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/20/05/18 (2)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6/20/05/18 (2)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/20/05/18 (2)

Job Completion



6/20/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

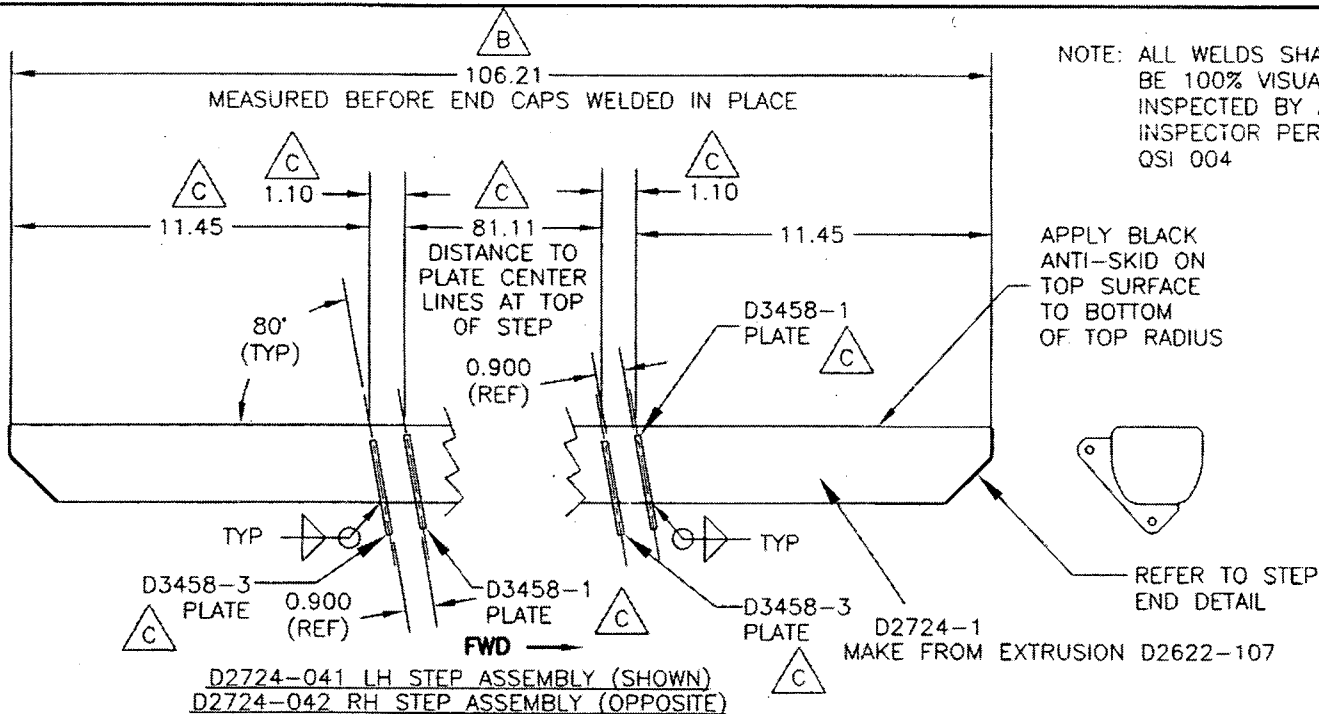
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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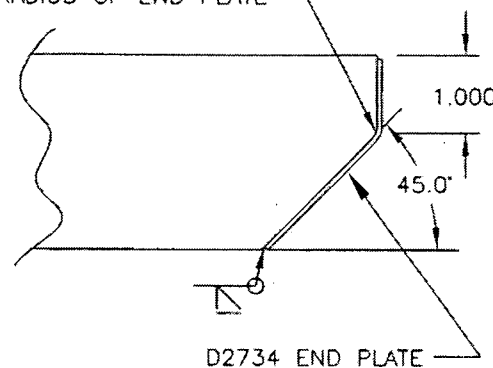
NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 TYPICAL S
2) WELD PER DART QSI 004 NOT
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0514

DAFT

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. C
				D2724	SHEET 1 OF 1
DATE			TITLE		SCALE
05.09.19			206L/407 STEP ASSEMBLY		NTS
A		97.12.04	NEW ISSUE		
B		98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES		
C		05.09.19	RE-DESIGN, ADD D3458-1/-3		